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IS 699-2 (1993): Textile machinery and accessories - Cross wound spool centres for jute winding machines, Part 2: Spool centres for precision winding machines [TXD 14: Machinery for Fabric Manufacture]



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Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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IS 699 (Part 2) : 1993

भारतीय मानक

वस्त्रादि मशीनरी एवं सहायकांग — पटसन आवलन मशीनों के लिए
अनुप्रस्थ आवलित स्पूल केन्द्र — विशिष्ट

भाग 2 परिशुद्ध आवलन मशीनों के लिए स्पूल केन्द्र

Indian Standard

TEXTILE MACHINERY AND ACCESSORIES —
CROSS WOUND SPOOL CENTRES FOR
JUTE WINDING MACHINES — SPECIFICATION

PART 2 SPOOL CENTRES FOR PRECISION WINDING MACHINES

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

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Price Group 2

FOREWORD

This Indian Standard was adopted by the Bureau of Indian Standards, after the draft finalized by the Jute Mill Machinery/Accessories and Spare Parts Sectional Committee, had been approved by the Textile Division Council.

This first part of the standard covers the specification for spool centres for spool winding machines.

For the purpose of deciding whether a particular requirement of this standard is complied with the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value shall be the same as that of the specified value in this standard.

Indian Standard

TEXTILE MACHINERY AND ACCESSORIES — CROSS WOUND SPOOL CENTRES FOR JUTE WINDING MACHINES — SPECIFICATION

PART 2 SPOOL CENTRES FOR PRECISION WINDING MACHINES

1 SCOPE

This standard prescribes the requirements of cylindrical and conical spool centres for use in different types of jute precision winding machines.

2 REFERENCES

The following Indian Standards are necessary adjuncts to this standard:

IS No.	Title
196 : 1966	Atmospheric conditions for testing (<i>revised</i>)
707 : 1976	Glossary of terms applicable to timber technology and utilization (<i>second revision</i>)
1141 : 1973	Code of practice of seasoning of timber (<i>first revision</i>)
2500 (Part 1) : 1973	Sampling inspection tables: Part 1 Inspection by attributes and by count of defects (<i>first revision</i>)

3 GENERAL REQUIREMENTS

3.1 Material

The spool centre may be made of paper, synthetic material or any of the species of timber listed in Annex A in accordance with the contract or order.

3.1.1 Timber used for the manufacture of spool centres shall be seasoned (*see* IS 1141 : 1973) before use.

3.1.2 Wooden spool centres shall be free from visible defects such as checks, splits, gum veins, bark pockets, hole or any other defect which is likely to affect the life or usefulness (for the description of defects *see* IS 707 : 1976). The surface shall be sanded smooth.

3.1.3 Synthetic as well as paper spool centres shall have uniformly distributed embossing on the surface.

4 SPECIFIC REQUIREMENTS

4.1 Dimensions and Mass

The spool centres of various types shall comply with the dimension and mass specified in

Tables 1 and 2 when read with Fig. 1 and 2 respectively in accordance with the contract or order.

4.2 Concentricity

The spool centres shall be concentric, the concentricity of spool centres shall, however, not exceed 1.5 mm in case of cylindrical spool centres and 0.8 mm in case of conical spool centres.

4.3 Position of the Groove in Cylindrical Spool Centre

The distance between the groove and the end shall be same at both the ends of cylindrical spool centres (*see* Fig. 1).

5 METHOD OF TEST

5.1 The dimensions, mass and concentricity of the spool centres shall be checked by the use of suitable calipers, gauges and balance.

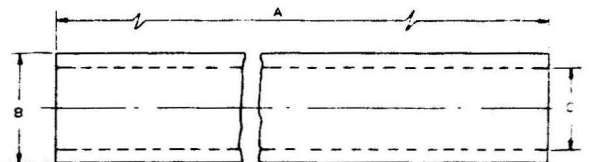


FIG. 1 CYLINDRICAL SPOOL CENTRE FOR PRECISION WINDING MACHINE

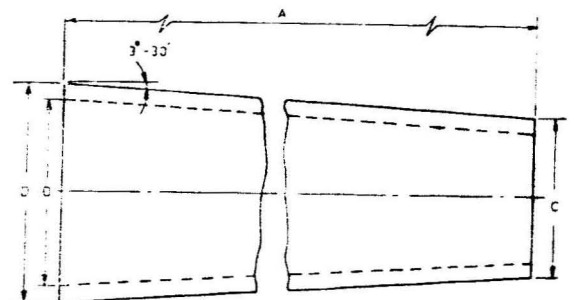


FIG. 2 CONICAL CENTRE FOR PRECISION WINDING MACHINE

Table 1 Dimension of Cylindrical Spool Centres for Different Types of Jute Precision Winding Machines
(Clause 4.1 and Fig. 1)

Type	Length A	Inside Dia B	Outside Dia C	Grooves			
				No. of Grooves D	Width E	Depth F	Mass of 100 Spool Centre
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)
	mm	mm	mm		mm	mm	kg
Paper	260	25.0	33.0	—	—	—	6.0
Timber	260	25.0	44.0	3	5	2.5	12.5
Tolerance	± 2	$+ 0.5$ $- 0$	± 1.0	—	—	—	$+ 2.0$ $- 1.5$

Table 2 Dimension of Conical Spool Centres for Jute Precision Winding Machines
(Clause 4.1 and Fig. 2)

Length A	Inside Dia B	Outside Dia at Bottom C	Grooves		
			Circular E	Triangular	
				X	Y
(1)	(2)	(3)	(4)	(5)	(6)
mm	mm	mm			
260	58.8	68.0	2-4	2-3	2-3
Tolerance	± 2	$+ 0.5$ $- 0$	± 1.0	—	—

5.2 In case of dispute or if agreed to between the buyer and the seller, the test sample shall be conditioned to moisture equilibrium and tested in the standard atmospheric conditions, that is (65 ± 2) percent relative humidity and $27 \pm 2^\circ\text{C}$ temperature (see also IS 196 : 1966).

6 MARKING

6.1 Each spool centre shall be marked with the following informations:

- a) Indication of the source of manufacture;
- b) Date of manufacture;
- c) Batch number; and
- d) Dimensions of the spool.

6.1.1 The spool centres may also be marked with the Standard Mark.

7 PACKING

7.1 The spool centres shall be packed in accordance with the agreement between the buyer and the seller.

8 SAMPLING AND CRITERIA FOR CONFORMITY

Unless otherwise agreed to between the purchaser and the manufacturer to ascertain the conformity of the spool centres for jute winding machines to the requirements of this specification, single sampling plan with Inspection Level 1 and Acceptance Quality Level (AQL) of 2.5 percent given in Tables 1 and 2 of IS 2500 (Part 1) : 1973 shall be followed.

ANNEX A

(Clause 3.1)

LIST OF RECOMMENDED SPECIES OF TIMBER FOR THE MANUFACTURE
OF WOODEN SPOOL CENTRES

	TRADE NAME	BOTANICAL NAME
Cylindrical spool centre	Amari	<i>Ammora</i> spp.
	Birch	<i>Betula</i> spp.
	Champ	<i>Michelia</i> spp.
	Chaplash	<i>Artocarpus chaplasha</i>
	Chikrassy	<i>Chukrasia velutina</i> (Syn. <i>C. tabularis</i>)
	Haldu	<i>Adina cordifolia</i>
	Hathipaila	<i>Pterospermum acerifolium</i>
	Kaim	<i>Mitragyna parvifolia</i> (Syn. <i>Stephegyne parvifolia</i>)
	Kurchi	<i>Holarrhena antidysenterica</i>
	Mango	<i>Mangifera</i> spp.
	Mokha	<i>Schrebera swietenoides</i>
	Pali	<i>Palaquium ellipticum</i>
	Pitraj	<i>Abhanamixis polystachya</i> (Syn. <i>Amoorarohituska</i>)
	Silver Oak	<i>Grevillea robusta</i>
	Toon	<i>Toona ciliata</i> (Syn. <i>Cedrela toona</i>)
Conical spool centre	Amari	<i>Amoora</i> spp.
	Birch	<i>Betula</i> spp.
	Champ	<i>Michelia</i> spp.
	Chikrassy	<i>Chukrasia velutina</i> (Syn. <i>C. tabularis</i>)
	Haldu	<i>Adina cordifolia</i>
	Hathipaila	<i>Pterospermum acerifolium</i>
	Kaim	<i>Mitragyna parvifolia</i> (Syn. <i>stephegyne-parvifolia</i>)
	Kurchi	<i>Holarrhena antidysenterica</i>
	Pali	<i>Palaquium ellipticum</i>
	Sandan	<i>Ougeina cojeinensis</i> (Syn. <i>O. dalbergioids</i>)
	Silver Oak	<i>Grevillea robusta</i>
	Mokha	<i>Schrebera swietenoides</i>
	Tendu-light coloured outer wood only	

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BUREAU OF INDIAN STANDARDS

Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002

Telephones : 331 01 31, 331 13 75

Telegrams : Manaksanstha
(Common to all offices)

Regional Offices :

Telephone

Central : Manak Bhavan, 9 Bahadur Shah Zafar Marg
NEW DELHI 110002

{ 331 01 31
{ 331 13 75

Eastern : 1/14 C. I. T. Scheme VII M, V. I. P. Road, Maniktola
CALCUTTA 700054

{ 37 84 99, 37 85 61
{ 37 86 26, 37 86 62

Northern : SCO 445-446, Sector 35-C CHANDIGARH 160036

{ 53 38 43, 53 16 40
{ 53 23 84

Southern : C. I. T. Campus, IV Cross Road, MADRAS 600113

{ 235 02 16, 235 04 42
{ 235 15 19, 235 23 15

Western : Manakalaya, E9 MIDC, Marol, Andheri (East)
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